

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 155313

Thursday, January 12, 2017 11:52:56 AM

155313

Page 2

Item ID: D350-607-547

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC	Memo	0.01							
Quality Control									
160		0.00							
160	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-547								
	Location ; FC096 BK002								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02							
Quality Control									

DAS
27
9-89

FEB 16 2017

DAS
27
9-89

FEB 16 2017

DAS
21
9-89

FEB 16 2017

DAS
21
9-89

FEB 16 2017

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 155313

155313

Parent Item: D350-607-547

D350-607-547

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP
REV:B 12.03.06 AS PER ECN12-535 DD VERF:EC IPP REV:C
12.07.24 AS PER ECN 12-610 DD VERF:EC IPP Rev:D 13.07.08 as
per CHG005 (ECN13-582) DD verf:JLM IPP REV:E 13.08.21 CHG006 / ECN
13-624 DD VERF:JLM IPP REV:F 14.06.10 AS PER ECN14-572 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4917-332		Manufactured	No			140	Each	7.0000	1	1			
D4917-332									**				
Placard, Max Load													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST137				7					
				141698				1					
				147809				6					
D350-607-511		Manufactured	No			140	Each	0.0000	1	1			
D350-607-511									**				
AS350/AS355 Quick Release Basket/Long Cargo Tube Mounting Provisions, Fits LH/RH													
D2690-6		Manufactured	No			140	Each	37.0000	1	1			
D2690-6									**				
Lanyard													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST009				37					
				152878				7					
				154343				30					

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Work Order ID: 155313

155313

Parent Item: D350-607-547

D350-607-547

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 1.00

Required Qty: 1.00

D3912-041 Manufactured No

140 Each 11.0000 1 1

D3912-041

Eyebolt Receiver Assembly

**

DAS 28
6 9-89
FEB 10 2017

DAS
27
9-89

Location	Loc Qty	Loc Code
ST057	8	
149505	4	
152172	4	
ST064A	3	
152893	3	

155651

D4032-043 Manufactured No

140 Each 0.0000 1 1

D4032-043

Short Basket Assembly, Light Lid (350)

**

DAS 28
6 9-89
FEB 10 2017

D4086-232

Manufactured No

140 Each 6.0000 1 1

D4086-232

Placard, Max Load

**

DAS 28
6 9-89
FEB 10 2017

DAS
27
9-89

Location	Loc Qty	Loc Code
ST078	6	
138955	6	

D4151-041 Manufactured No

140 Each 14.0000 1 1

D4151-041

Basket Fwd Hardpoint Assembly, Lower

**

DAS 28
6 9-89
FEB 10 2017

DAS
27
9-89

Location	Loc Qty	Loc Code
ST087	3	
151038	3	
ST090A	11	
151434	5	
151711	2	
153090	4	

1

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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			Completed By		
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			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Work Order ID: 155313

155313

Parent Item: D350-607-547

D350-607-547

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 1.00

Required Qty: 1.00

D4151-043

Manufactured No

140

Each

16.0000

1

1

D4151-043

Basket Fwd Hardpoint Assembly, Upper

DAS
6 28
9-89

FEB 10 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST088

6

151135

4

151804

2

ST090A

10

152475

2

153150

4

153611

4

D4150-041

Manufactured No

140

Each

16.0000

1

1

D4150-041

Attachment Arm Assembly

DAS
6 28
9-89

FEB 10 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST087

6

149663

6

ST090A

10

152256

2

153117

4

153606

4

DQA: _____ Date: _____



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							Completed By 		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

Picklist Print

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Work Order ID: 155313

155313

Parent Item: D350-607-547

D350-607-547

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

140

Each

509.0000

6

6

AN4-13A

Bolt

**

DAS 6 28 9-89

FEB 1 2017

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

76

m134634

19

m135470

57

over003

350

m136263

250

m136406

100

ST344

63

m136147

63

AN4C15

Purchased

No

140

Each

36.0000

1

1

AN4C15

Bolt

**

DAS 6 28 9-89

FEB 1 2017

Location

Loc Qty

Loc Code

OVER002

20

M136182

20

ST343

16

M135704

16

AN310C4

Purchased

No

140

Each

88.0000

1

1

AN310C4

Nut

**

DAS 6 28 9-89

FEB 1 2017

Location

Loc Qty

Loc Code

OVER007

25

M136450

25

ST331

63

M135297

28

M135895

35

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 155313

155313

Parent Item: D350-607-547

D350-607-547

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

Purchased

No

140

Each

28.0000

1

1

MS17984-C413

Quick Release Pin

DAS
28
9-89
DAS
6
9-89

Location

Loc Qty

Loc Code

over005

25

153303

15

153942

10

ST315

3

151622

3

DAS
27
9-89

MS21042L4

Purchased

No

140

Each

2,305.000

6

6

MS21042L4

Nut

DAS
28
9-89
DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

192

m135058

192

OVER007

1000

m136182

500

m136450

500

ST303

1095

m135864

24

m135979

71

m136295

1000

DAS
27
9-89

136648

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DQA: _____ Date: _____



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Description Work Order Deviation				Disposition					
							Completed By Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Misabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								☐ OTHER : _____																																							

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Work Order ID: 155313

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Parent Item: D350-607-547

D350-607-547

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

140

Each

182.0000

1

1

MS24665-151

Cotter Pin

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

60

m128401

60

ST289

122

m135274

22

m136444

100

NAS1515H4L

Purchased

No

140

Each

437.0000

2

2

***NAS1515H4L ***

Washer

DAS
6
9-89

FEB 10 2017

FEB 10 2017

Location

Loc Qty

Loc Code

FG

23

103691

3

m132189

20

ST260

38

m131026

38

ST260a

376

m131697

63

m132189

87

m133483

138

m134376

88

NAS1149F0432P

Purchased

No

140

Each

1,639.0000

12

12

NAS1149F0432P

WASHER

DAS
6
9-89

FEB 10 2017

Location

Loc Qty

Loc Code

ST260a

1000

M136442

1000

ST262

639

M135704

639

Thursday, January 12, 2017 11:53:02 AM

Shop Packet Print

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 7

Thursday, January 12, 2017 11:53:02 AM

Work Order ID: 155313

155313

Parent Item: D350-607-547

D350-607-547

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0463R

Purchased

No

140

Each

370.0000

3

3

NAS1149C0463R

Washer

**

DAS
6
9-89

FEB 1st 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

34

m127306

34

ST266

336

m134167

136

m136263

200

3

Thursday, January 12, 2017 11:53:02 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV.6 ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 155313

THIS SERVICE INSTRUCTION PROVIDES PARTS AND INSTRUCTIONS TO FACILITATE INSTALLATION OF FORWARD BASKET STRUT FOR JAN 1 2 2017

customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heil-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY	-541	-543	-545	-547	-511	-501	PART NUMBER	DESCRIPTION
X							D350-607-541	HEIL-UTILITY-BASKET @ CHG 007 OR LATER
	X						D350-607-543	HEIL-UTILITY-BASKET @ CHG 008 OR LATER
		X					D350-607-545	HEIL-UTILITY-BASKET @ CHG 007 OR LATER
			X				D350-607-547	HEIL-UTILITY-BASKET @ CHG 005 OR LATER
1				1			D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X		D3910-5	X-TUBE LUG
						1	D3910-7	X-TUBE LUG

QTY	-413	-415	-417	-419	-431	PART NUMBER	DESCRIPTION
X						D350-607-413	HEAVY DUTY LID KIT (LONG)
		X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
			X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
				X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
					X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
						D3910-5	X-TUBE LUG
						D3910-7	X-TUBE LUG

QTY	-641	-611	-511	-431	PART NUMBER	DESCRIPTION
X					D350-607-641	QUICK RELEASE LONG CARGO TUBE
1		X			D350-607-611	LONG CARGO TUBE
			X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
					D3910-5	X-TUBE LUG
					D3910-7	X-TUBE LUG

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A NEW ISSUE

REV. DATE

DESIGN AJS

DRAWN AJS

CHECKED

MFG. APPR. N/A

APPROVED

DE APPR.

DATE 14.05.16

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. DSI 9699

SHEET 1 OF 2

REV. A

SCALE

NTS

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3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.

3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).

3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

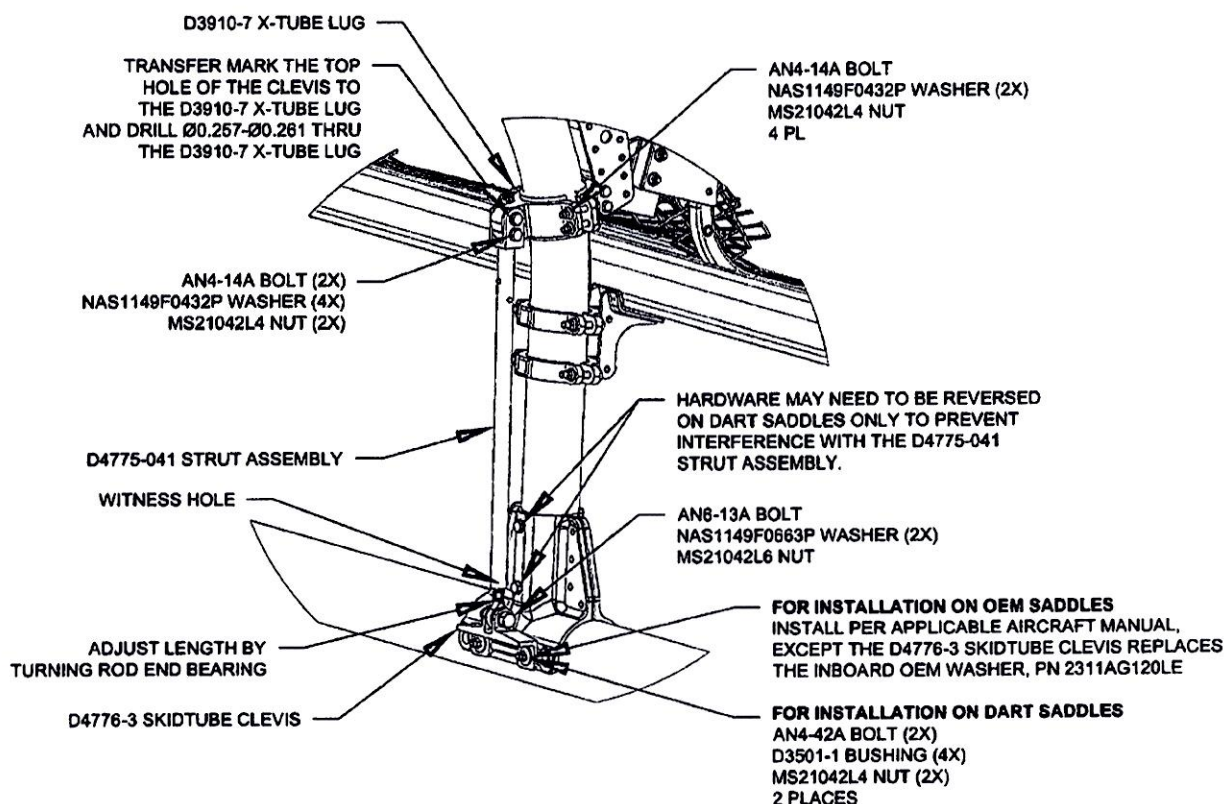


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED BY: <i>[Signature]</i> D. SHEPHERD (DE # 02)	
DATE:	14.05.16
CERT. NO.:	SH94-14
ISSUE NO.:	6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 155313

Thursday, February 09, 2017 9:28:57 AM

155313

Page 1

Item ID: D350-607-547

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™, Short, Lightweight Lid

Start Date: 1/12/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	D								
DSI9699	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-547 CHG008								
140	Pick Kit	0.00							
140									
Packaging	Memo	0.00							
Packaging									

DAS
21
9-89
Label

FEB 09 2017

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				2	2	D3910-5	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER